



Dart Hawkesbury
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Hawkesbury, ON
K6A 1K7
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D4634-141
Job Sheet 167074-F



Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/23/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start up container	2017-12-14 JSC
100	HandThermo	1 pcs		11/23/17	0.00	1.65	HandFinish4	12/12/18 BG
110	Small Fab	1 pcs		11/24/17	0.00	1.47	Small Fab	17/12/18 BG
120	QC	1 pcs		11/24/17	0.00	0.00	QC5	DEC 1 2017
130	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3	D.M.L 17-12-27
140	QC21-SA	1 Ea		11/24/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 18/01/24 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 132435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	- D4634-1 5021553	1	3	0	0
	- D4636-5 5021552	1	43	0	0
	- D4647-5 5021550	1	2	0	0
	- D4664-5 5021549	6	39	0	0
	- D4712-1 5021548	1	4	0	0
	- D4732-15 5021545	1	2	0	0
	- D4732-19 5021544	1	1	0	0
	- D5021-1 5021542	1	2	0	0
	- MPNY-750S-9-C 5021540	7	570	0	0
	- MS20426AD3-4 5021539	4	5,055	0	0
	- MS20426AD4-6 5021538	2	2,797	0	0
	- MS21059L08 5021537	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Mfg Date: 12/14/17 Job No: 167074 – F	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 25%;"> Skid-tube ☐ Machining ☐ rmoforming ☐ Large Fab ☐ </td> <td style="width: 25%;"> Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 25%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 25%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ rmoforming ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐	
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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632 – 5200 Email: sales@dartaero.com www.dartaerospace.com S021720 Fwd, Center Ceiling Replacement Panel Assembly D4634 – 141 Start up Operation		QTY Effective : _____ Disposition 	MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
		FAULT CATEGORY <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;"> emperature/Cure ☐ p ☐ /Route ☐ en/Damage/Defect ☐ iction Incomplete/Unqualified ☐ amination ☐ itersink ☐ oo Short ☐ uctions Incomplete/Unclear ☐ </td> <td style="width: 50%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>		emperature/Cure ☐ p ☐ /Route ☐ en/Damage/Defect ☐ iction Incomplete/Unqualified ☐ amination ☐ itersink ☐ oo Short ☐ uctions Incomplete/Unclear ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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